



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-C-1A

Job Sheet 197534



Part No: RBE350A94-3700-C-1A

Job Qty: 6 pcs

Part Name: Adjustable Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/10/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/2/19

Description:

Type: Stock

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Small Fab - 1	6 pcs	9/2/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	6 pcs	9/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	6 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

GP 19-10-16

OCT 18 2019
DAS
40
9-89

DAF
28
9-89

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	6 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21	DAF 21 9-89
					QC 21 - SA - 70	
					QC 21 - SA - 53	

OCT 22 2019

Part Op 100 - Small Fab-3 (Small Fab) -Assemble as per DWG sheet 2
 Descriptions: 110 - QC5 (QC5- Inspect part completeness to step on W/O)
 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____)
 140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	12 Ea (2 ea)	100-Small Fab - 1	5215202
92373A181	Roll Pin 1/8 X 3/4	12 Ea (2 ea)	100-Small Fab - 1	5214319
92373A251	Slotted Spring Pin	6 Ea (1 ea)	100-Small Fab - 1	5214323
CL-2-C	Lanyard Wire	4.9980 ft (.833 ea)	100-Small Fab - 1	5192012
NAS1756-12	Remove Before Flight	6 Ea (1 ea)	100-Small Fab - 1	5200859
RBE350A94-3700-C-01	Tube	6 pcs (1 ea)	100-Small Fab - 1	5206507
RBE350A94-3700-C-03	Bolt	6 pcs (1 ea)	100-Small Fab - 1	5191162
RBE350A94-3700-C-05	Bottom	6 pcs (1 ea)	100-Small Fab - 1	5184049
RBE350A94-3700-C-07	Top	6 pcs (1 ea)	100-Small Fab - 1	5184522
RBE350A94-3700-C-09	Knurled Nut	6 pcs (1 ea)	100-Small Fab - 1	5188469

012432

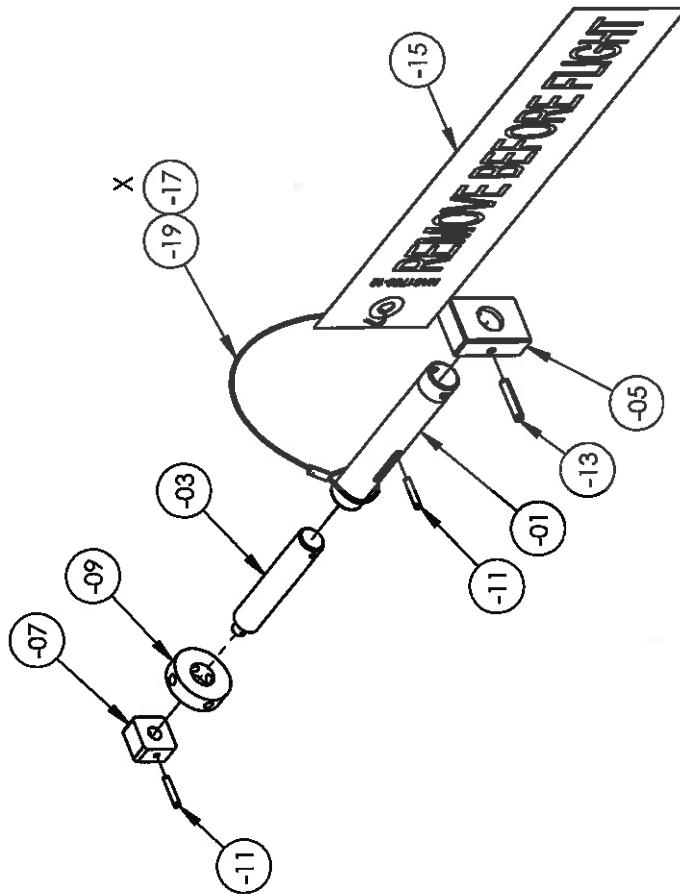
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	12	519	0
	92373A181	12	117	0
	92373A251	6	62	0
	CL-2-C	5	1,241	0
	NAS1756-12	6	134	0
	RBE350A94-3700-C-01	6	27	0
	RBE350A94-3700-C-03	6	5	0
	RBE350A94-3700-C-05	6	40	0
	RBE350A94-3700-C-07	6	42	0
	RBE350A94-3700-C-09	6	28	0
Part Specifications				
Specifications could not be found.				

Plex 7/10/19 9:01 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dait Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dait Aerospace Engine, Co.

REVISIONS			
REV	ECR	DESCRIPTION	
6	16-0286	-1A ADDED DRAWING.	

DATE	INITIAL	APPROVED
2/28/2017	RJC	SM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NC 19754 MCS
1907-10



TITLE		REV	
SWASHPLATE IMMOBILIZING TOOL		6	
ADJUSTABLE BRACE		RBE350A94-3700-C-1A	
Dwg No.		REV	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		XXX ± .005 FRACTIONS ± 1/8	
SPEC		XX ± .01 ANGLES ± 1°	
DRAWN BY:		SURFACES = 125/	
CHECKED:		1. BREAK ALL SHARP EDGES	
OFFS APPR:		.015 X .46" OR .016"	
QA APPR:		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		3. AFTER PLATING	
SCALE		3. INTERPRET DIM AND TOL PER	
1:4		ASME Y14.5M-2009	
DATE		USED ON MODEL	
8/21/2012		EUROCOPTER AS350/355	
SHEET 2 OF 7			

-1A
ADJUSTABLE BRACE ASSEMBLY

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS																												
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (Q51042)																												
Description Work Order Deviation		Disposition																														
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>			Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																													
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																													
Crushing	BOM/Route	Grain Direction	Drawing																													
Cracks	Broken/Damage/Defect	Weld	Finish																													
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																													
Marks/Chatter	Drill Holes	Out of Sequence	Misread																													
Mislabeled	Fit/Function	Off-set/Set-up																														
Completed By		Lead hand / Supervisor																														
QC / QA Coordinator																																